

Tuesday, February 21, 2017 7:57:55 AM

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9-89
A 1 2017

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[illegible]

Work Order ID 157227

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157227

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Item ID: D3639-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 2/14/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 2/17/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				4			DAS 38 9-89 MAR 08 2017
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>Stock</u> Memo	0.00 0.01				4			DAS 6 9-89 MAR 10 2017
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.07							17/3/13 [Signature] DAS 21 9-89 MAR 10 2017

Picklist Print

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Work Order ID: 157227

157227

Parent Item: D3639-1

D3639-1

Parent Item Name: Doubler

Start Date: 2/14/2017

Required Date: 2/17/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	65.4500	0.239	1.006316			
M2024T3S 050													
2024-T3 .050 sheet													

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17/03/01

**

Location	Loc Qty	Loc Code
MAT022	65.450026	
m131564	0.55	
m134581	32.1	
m135610	32.800026	

1.5

DART AEROSPACE LTD		Work Order: 157227
Description: Doubler		Part Number: D3639-1
Inspection Dwg: D3639	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

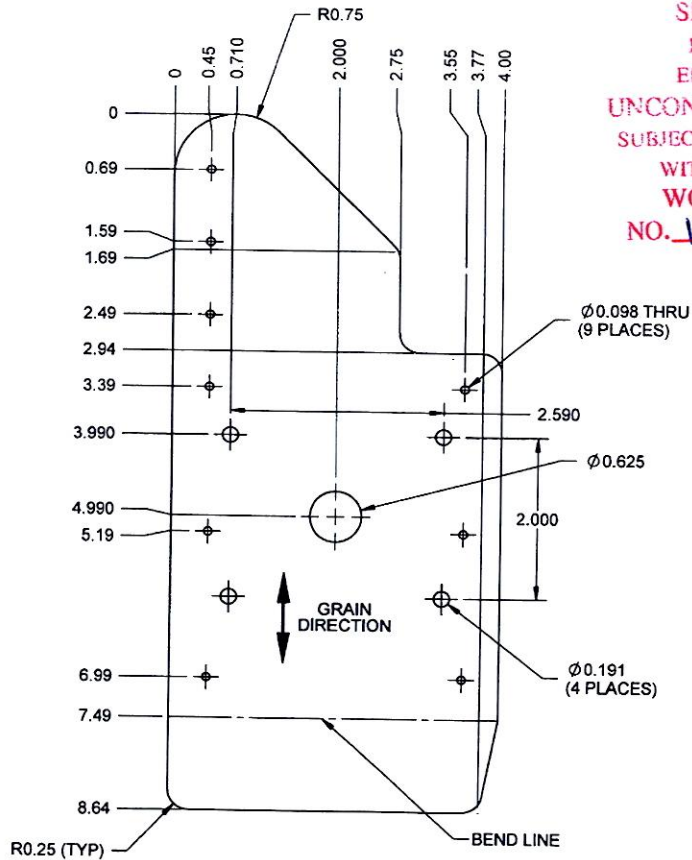
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	0.627	✓		DC-01	
Ø0.191	+0.005/-0.001	0.192	✓			
Ø0.098	+0.004/-0.001	0.099	✓			
0.69	+/-0.030	0.69	✓			
1.59	+/-0.030	1.59	✓			
2.49	+/-0.030	2.49	✓			
3.39	+/-0.030	3.39	✓			
3.990	+/-0.010	3.988	✓			
4.990	+/-0.010	4.990	✓			
5.19	+/-0.030	5.19	✓			
6.99	+/-0.030	6.99	✓			
8.64	+/-0.030	8.642	✓			
0.45	+/-0.030	0.452	✓			
0.710	+/-0.010	0.713	✓			
2.000	+/-0.010	2.004	✓			
2.75	+/-0.030	2.754	✓			
3.55	+/-0.030	3.558	✓			
4.00	+/-0.030	4.006	✓			
2.000	+/-0.010	2.003	✓			
2.590	+/-0.010	2.590	✓			
	DAS 46					

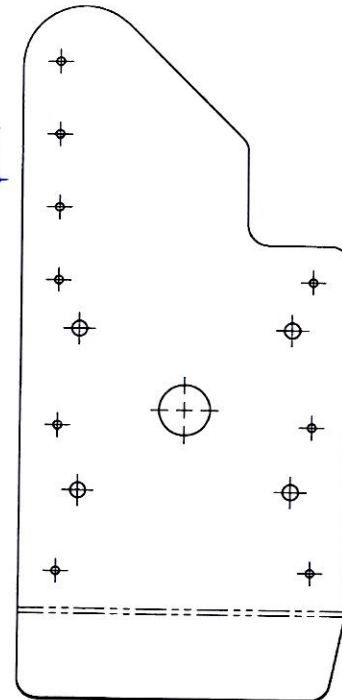
Measured by: 9-89	Audited by: DAS 38	Prototype Approval:	N/A
Date: 17/03/01	Date: MAR 9 2017	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	

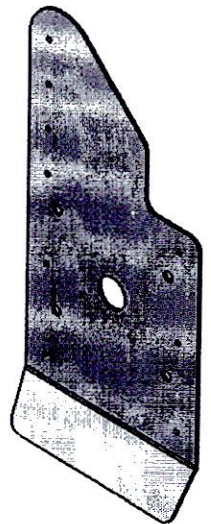
SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 157227 MLS
1702-22



D3639-1F FLAT PATTERN
(D3639-2F OPPOSITE)



D3639-1 DOUBLER
(WAS GENEVA P/N G10604-3)
D3639-2 OPPOSITE
(WAS GENEVA P/N G10604-6)

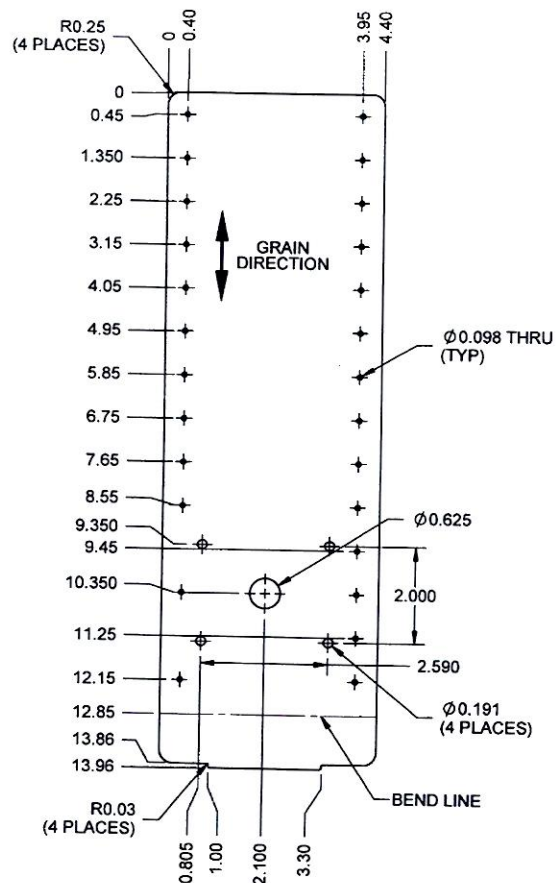


RELEASED
07-07-27

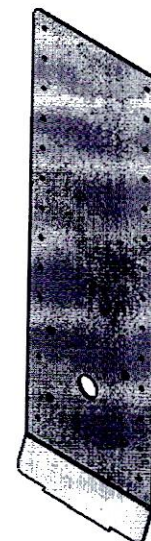
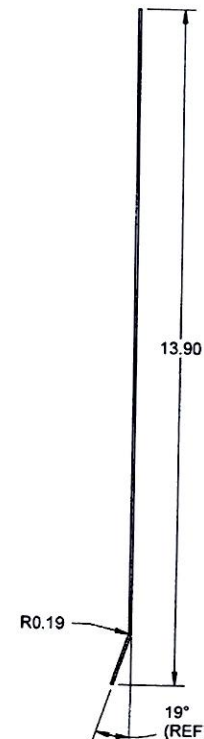
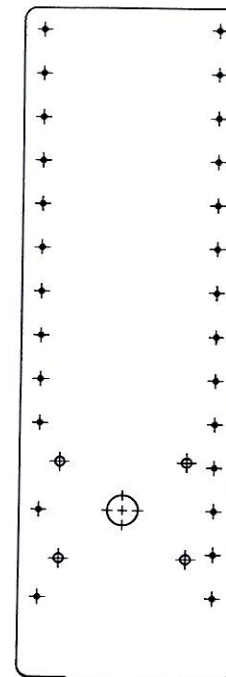
- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.14 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE: REPLACES G10604	LE	07.07.27
DESIGN	TS		
DRAWN	LE		
CHECKED	LE		
MFG. APPR.	LE		
APPROVED	LE		
DE APPR.	LE		
DATE	07.07.27		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D3639	REV. A
TITLE DOUBLER	SCALE 2:3
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**D3639-3F FLAT PATTERN
(D3639-4F OPPOSITE)**



**D3639-3 DOUBLER
(WAS GENEVA P/N G10604-4)
D3639-4 OPPOSITE
(WAS GENEVA P/N G10604-5)**

RELEASED
07-09-07

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	E	D3639	SHEET 2 OF 2
APPROVED	MD	TITLE	SCALE
DE APPR.	#	DOUBLER	2.5
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